

Date: Wednesday, 11/03/2009 12:58:39 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: TUBE		
Job Number	: 46429			Part Number	: D22825		
Estimate Number	: 11175			Drawing Number	: D2282 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 11/03/2009 S.O. No. :			Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: // Type : MACHINED PARTS			Due Date	: 31/03/2009 Qty: 200 Um: Each		
Previous Run	: 45385						
Written By	:						
Checked & Approved By	: <u>JD 09.03.11</u>						
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM						
	EstRev:B Now on Doosan Lathe 08-06-05 JLM						
	Verified By:EC						

Additional Product

Job Number:				
Seq. #:	Machine Or Operation:	Description :		
1.0	M304R0750	304 SS Roundbar .750 		
Comment: Qty.: 0.1891 f(s)/Unit Total : 37.8126 f(s) <u>1110912 (x167) + 5.647' 12.669' + 18.91'</u> Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch <u>M110166 x 16 parts 3.025'</u> <u>mk / M 09/03/17</u>				
2.0	DOOSAN LATHE	DOOSAN LATHE 		
Comment: DOOSAN LATHE 1-Turn as per Dwg D2282 and Folio FA189				
2-Deburr 				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mk / M 09/03/17 183</u>				
4.0	QC8	SECOND CHECK 		
Comment: SECOND CHECK <u>09/03/17 183</u>				
5.0	PACKAGING 1	PACKAGING RESOURCE #1 		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>5A Hanger Cau 1 9/3/10</u> <u>SP</u>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 46429

Part Number: D22825

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/18 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46429
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

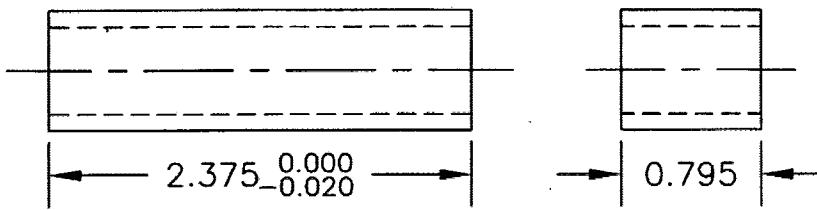
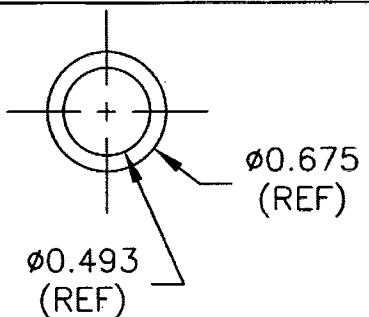
Measured by:	<u>ml</u>	Audited by:	<u>bd</u>	Prototype Approval:	N/A
Date:	09/03/15	Date:	09/03/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	KA DS

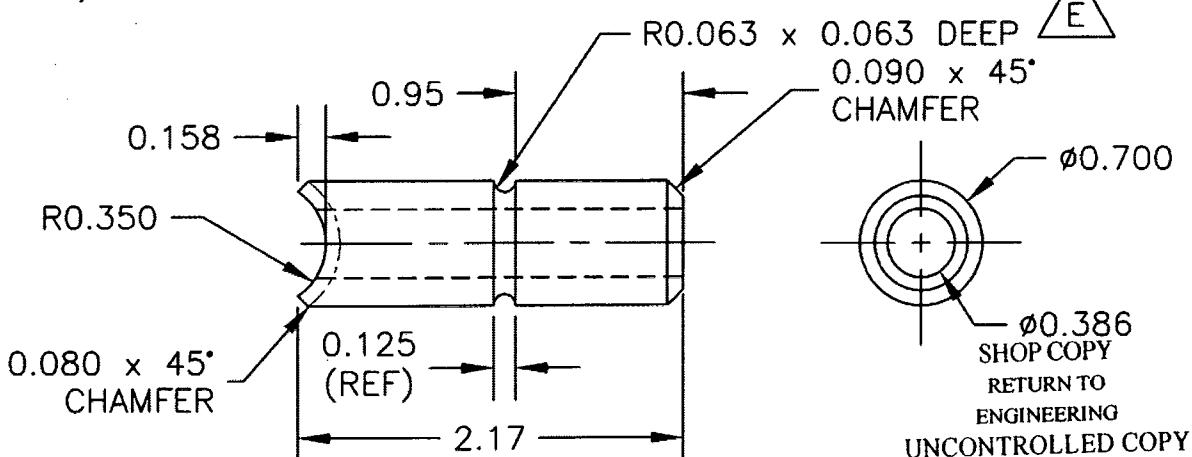
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]
BS/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. *[Signature]*
H-1449

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DART

DESIGN

BW

DRAWN BY

RF

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

UP

APPROVED

AB

DRAWING NO.

D2282

REV. E

SHEET 2 OF 2

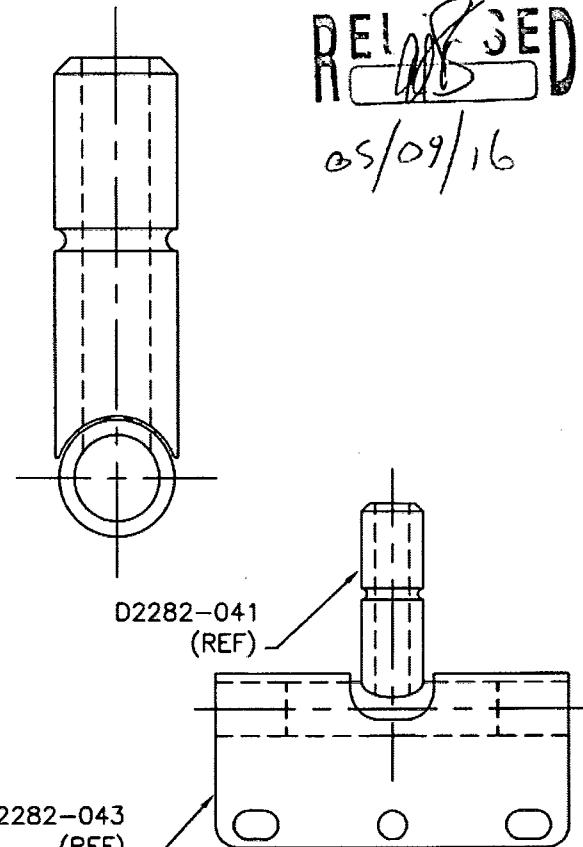
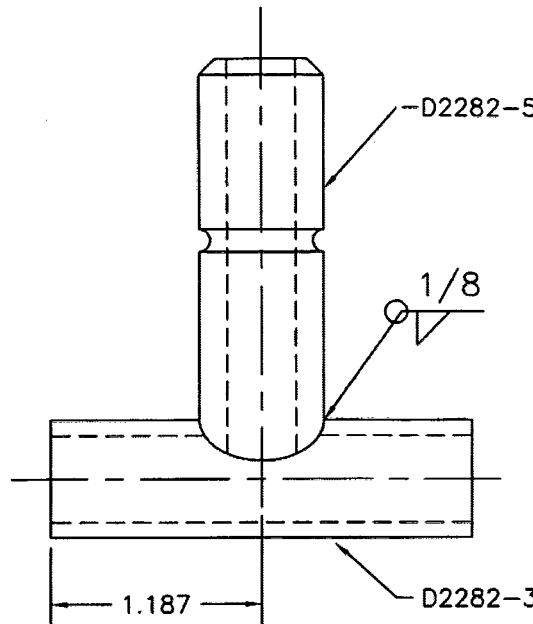
DATE

05.06.07

TITLE

HANDLE TUBES

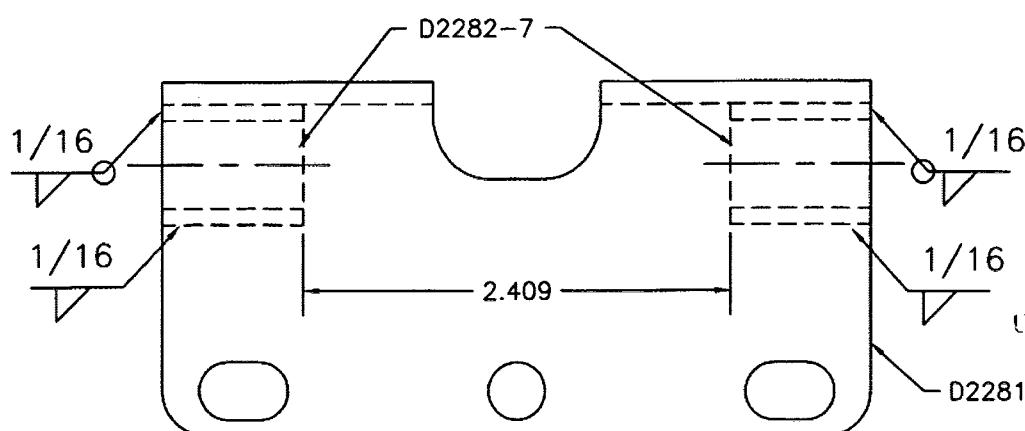
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D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



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D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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